



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D130-1048-012
Job Sheet 196755



Part No: D130-1048-012

Job Qty: 1 pcs

Part Name: H130/EC130 - Skidtube - Standard w/ Basic Wearplates - RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/20/19

Job Tracking No:

Due Date: 7/12/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D130-1048-012 REV.C/ IIN-D130-1048 REV.C IPP REV:A DP verify DD 17.07.09

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Sign-off
110	Handfinish - 4 - Assembly	1 pcs	7/12/19		0.00	1.00	Handfinish - 4 - 1	
							Handfinish - 4 - 10	
							Handfinish - 4 - 11	
							Handfinish - 4 - 12	
							Handfinish - 4 - 13	
							Handfinish - 4 - 14	
							Handfinish - 4 - 15	
							Handfinish - 4 - 2	
							Handfinish - 4 - 3	
							Handfinish - 4 - 4	
							Handfinish - 4 - 5	
							Handfinish - 4 - 6	
							Handfinish - 4 - 7	
							Handfinish - 4 - 8	
							Handfinish - 4 - 9	
120	QC 5	1 pcs	7/12/19		0.00	0.00	QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	
							QC 5 - 50	
							QC 5 - 30	



Container No: S212723



Part: D130 - 1048 - 012

Job No: 196755

Serial No/Batch: S212723

Revision: C/C

Inspector:

Exp Date:

Instructions: TC STC SH19 - 4 Issue 1, FAA STC SR04320N

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Email: sales@dartaero.com
www.dartaerospace.com

SEP 11 2019

C/Scan

130 Packaging 1-1 - Pick Kit - B4B 1 pcs	7/12/19	0.00 0.00	QC 5 - 40	
			Packaging 1 - 1 - B4B	✓
			Packaging 1 - 2 - B4B	
			Packaging 1 - 3 - B4B	
			Packaging 1 - 4 - B4B	
			Packaging 1 - 5 - B4B	
			Packaging 1 - 6 - B4B	
			Packaging 1 - 7 - B4B	
			Packaging 1 - 8 - B4B	
			Packaging 1 - 9 - B4B	
			Packaging 1 - 10 - B4B	
			Packaging 1 - 11 - B4B	
			Packaging 1 - 12 - B4B	
			Packaging 1 - 13 - B4B	
			Packaging 1 - 14 - B4B	
			Packaging 1 - 15 - B4B	
			Packaging 1 - 16 - B4B	
			Packaging 1 - 17 - B4B	
			Packaging 1 - 18 - B4B	
			Packaging 1 - 19 - B4B	
			Packaging 1 - 20 - B4B	
			Packaging 1 - 21 - B4B	
			Packaging 1 - 22 - B4B	
			Packaging 1 - 23 - B4B	
			Packaging 1 - 24 - B4B	
			Packaging 1 - 25 - B4B	
			Packaging 1 - 26 - B4B	
			Packaging 1 - 27 - B4B	
			Packaging 1 - 28 - B4B	
			Packaging 1 - 29 - B4B	
			Packaging 1 - 30 - B4B	
			Packaging 1 - 31 - B4B	
			Packaging 1 - 32 - B4B	
			Packaging 1 - 33 - B4B	
			Packaging 1 - 34 - B4B	
			Packaging 1 - 35 - B4B	
			Packaging 1 - 36 - B4B	
135 QC 4 1 pcs	7/12/19	0.00 0.00	QC 4 - 28	
			QC 4 - 58	
			QC 4 - 69	
			QC 4 - 9	
			QC 4 - 46	
			QC 4 - 68	
			QC 4 - 72	
			QC 4 - 74	
			QC 4 - 75	
140 Packaging 3-1 - Stock - B4B 1 pcs	7/12/19	0.00 0.00	Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	

MoxB.

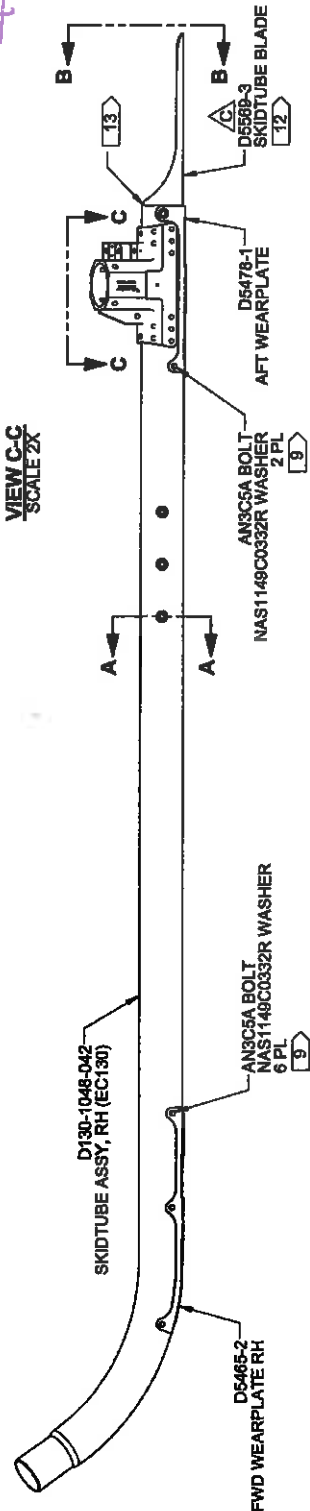
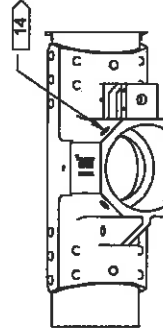
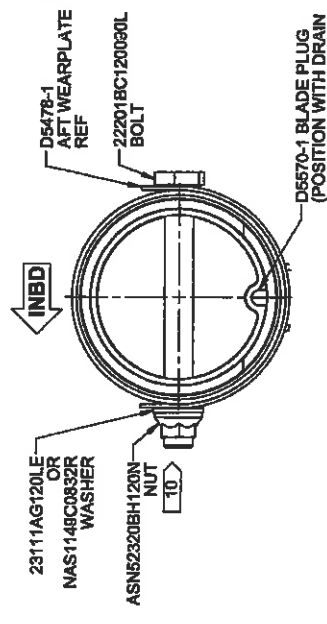
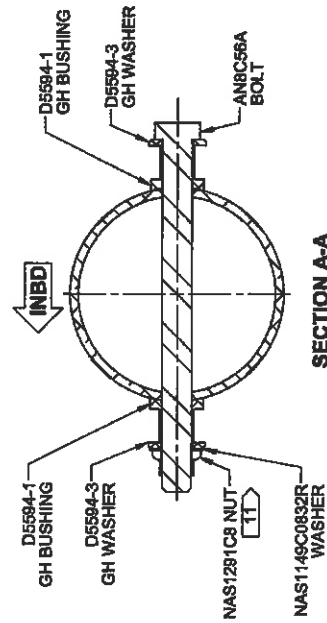
9/18/2019

					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
155 DC - 1 - B4B	OK	1 pcs	7/12/19	0.00 0.00	DC - 1 - B4B	SEP 24 2019
165 QC 21 - SA	OK	1 pcs	7/12/19	0.00 0.00	DC - 2 - B4B	
					QC 21 - SA - 21	DAS
					QC 21 - SA - 70	70
					QC 21 - SA - 53	9-89

Part Op 110 - ASSEMBLE AS PER DWG SEE DWG NOTES 9) TORQUE BOLT TO 15 - 25 in-lbs 10) TORQUE NUT TO 44 - 62
Descriptions: in-lbs 11) TORQUE NUT TO 62 - 71 in-lbs 12) SEAL FAYING SURFACES WITH SIKAFLEX-241/-291 13) FILLET SEAL
 WITH SIKAFLEX-241/-291 14) PLUG SEAL SADDLE HOLES WITH SIKAFLEX-241/-291 SEALANT ENSURE SADDLE
 BORE IS FREE OF SEALANT
120 - QC5- Inspect part completeness to step on W/O
130 - Pick Kit BAG AND ID HARDWARE.
135 - QC4- 100% Inspect kits for completeness
140 - Identify and pack for shipping as per PPP D130-1048-012 Location: _____ PPP Rev: _____
155 - Document Control - Photocopy blue file and create labels as per PPP D130-1048-012 chg 001
165 - QC21- Final Inspection - Work Order Release

Job BOM					011563
Part / Item	Component Name	Quantity	Operation	Container	
22201BC120090L	Bolt	1 Ea (1 ea)	110-Handfinish - 4 - Assembly		5197858
23111AG120LE	Washer	1 Ea (1 ea)	110-Handfinish - 4 - Assembly		5135792
AN8C56A	Bolt	3 Ea (3 ea)	110-Handfinish - 4 - Assembly		5197957
ASN52320BH120N	Nut	1 Ea (1 ea)	110-Handfinish - 4 - Assembly		5207485
D130-1048-042	H130/EC130 - Replacement Skidtube - Standard - RH	1 pcs (1 ea)	110-Handfinish - 4 - Assembly		5263590
D130-1048-052	H130/EC130 - Wearplates - DART & OEM Replacement - Basic - RH	1 pcs (1 ea)	110-Handfinish - 4 - Assembly		5209817
D5569-3	Replacement Blade - Basic Aluminum	1 pcs (1 ea)	110-Handfinish - 4 - Assembly		5195753
D5570-1	Blade Plug	1 pcs (1 ea)	110-Handfinish - 4 - Assembly		5193414
D5594-1	GH Bushing	6 pcs (6 ea)	110-Handfinish - 4 - Assembly		5196648
D5594-3	GH Washer	6 pcs (6 ea)	110-Handfinish - 4 - Assembly		5076017
NAS1149C0832R	Washer (AN960C816L)	3 Ea (3 ea)	110-Handfinish - 4 - Assembly		5112909
NAS1291C8	Nut, Self-Locking	3 Ea (3 ea)	110-Handfinish - 4 - Assembly		O.R
23111AG100LE	Washer	1 Ea (1 ea)	130-Packaging 1-1 - Pick Kit - B4B		5196062 ✓
ASNA0045BC100L	Nut, Castellated	1 Ea (1 ea)	130-Packaging 1-1 - Pick Kit - B4B		5109874 ✓
DHS411-101.3106	Metric Hex Head Aerospace Bolt	1 Ea (1 ea)	130-Packaging 1-1 - Pick Kit - B4B		5093539 ✓
MS21141S-06-05	Rivet	20 Ea (20 ea)	130-Packaging 1-1 - Pick Kit - B4B		5196061 ✓
MS24665-231	Cotter Pin	1 pcs (1 ea)	130-Packaging 1-1 - Pick Kit - B4B		M135671
04933					289
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-Handfinish - 4 - Assembly	22201BC120090L	1	0	0	
	23111AG120LE	1	40	0	
	AN8C56A	3	18	0	
	ASN52320BH120N	1	9	0	
	D130-1048-042	1	0	0	
	D130-1048-052	1	0	0	
	D5569-3	1	0	0	
	D5570-1	1	4	0	
	D5594-1	6	12	0	
	D5594-3	6	15	0	
	NAS1149C0832R	3	307	0	
	NAS1291C8	3	32	0	
	23111AG100LE	1	4	0	
	ASNA0045BC100L	1	6	0	
130-Packaging 1-1 - Pick Kit - B4B	DHS411-101.3106	1	4	0	
	MS21141S-06-05	20	90	0	
	MS24665-231	1	113	0	
Part Specifications					
Specifications could not be found.					

QTY -PIE	PIN	DESCRIPTION
1	D130-1048-012	BASIC SKIDTUBE INSTL, RH (EC130)
1	D5465-2	SKIDTUBE ASSY
1	D5478-1	FWD WEARPLATE
1	D5569-3	SKIDTUBE BLADE
1	D5570-1	BLADE PLUG
6	D5594-1	GH BUSHING
6	D5594-3	GH WASHER
1	22201BC120090L	BOLT
1	23111AG120LE	WASHER (OR NAS1149C0832R)
3	AN8C56A	BOLT, MACHINE
1	AN8C56A	NUT
3	NAS1149C0832R	WASHER
3	NAS1291C8	NUT, SELF-LOCKING
1	23111AG100LE	WASHER (OR NAS1149C0732R)
1	ASNA00468C100L	NUT, CATELLED
1	DHS411-101.3108	BOLT
1	EN2367-18028	COTTER PIN (OR MS24685-231)
20	MS2114190805	MAXIBOLT, BLIND, PAN HEAD (CR1621506-05)



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: N/A
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 25.98 lbs
 - 8) HARDWARE NOT SHOWN. TO BE SHIPPED LOOSE.
 - 9) TORQUE BOLT TO 13 - 25 ft-lbs
 - 10) TORQUE NUT TO 44 - 92 ft-lbs
 - 11) TORQUE NUT TO 62 - 71 ft-lbs
 - 12) SEAL FAYING SURFACES WITH SIKAFLEX-241/281
 - 13) FILLET SEAL WITH SIKAFLEX-241/281
 - 14) PLUG SEAL SADDLE HOLES WITH SIKAFLEX-241/281 OR PROSEAL 880 OR EQUIVALENT MIL-S-8802 SEALANT

RELEASED
2019 JUN 18 NO
ECN19-625

REV.	DESCRIPTION	DATE
C	REPLACED SKIDTUBE BLADE D5569-3 WAS -1	19.05.06
B	REDRAWN, ADDED VIEWS B, B & C, ADDED ALTERNATE HARDWARE, ADDED TORQUE AND SEALANT NOTES	19.02.06
A	NEW ISSUE	18.05.06
DESIGN	NO	BY
DRAWN	ZF	DATE
CHECKED	MM	
MFG. APPR.	JFS	
APPROVED	NO	
DE APPR.	CP	
DATE	19.04.05	

APPROVED

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D130-1048-012

REV. C
SHEET 1 OF 1

TITLE
SKIDTUBE INSTL, RH (EC130)

DATE
19.04.05

NTS

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VIEW B-B SCALE 5X
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 196733
MCS
1906-20

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION			DEPARTMENT/PROCESS								
		Rework Scrap Use-as-is			Skid-tube Machining Large Fab		Cross tube Small Fab Finishing		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging		Engineering Water Jet Supplier Quality		
Date :	Sequence #:	QTY Affected :		MRB (QS1042)									
Description Work Order Deviation				Disposition									
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY									
				Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled		Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function		Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up		Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread			
				Other/Details:									
Completed By				Lead hand / Supervisor				QC / QA Coordinator					

5.0 PARTS LISTS

5.1 D130-1048-011/-012/-013/-014/-051/-052/-053 Skidtube and Wearplates

QTY -011	QTY -012	QTY -013	QTY -014	QTY -051	QTY -052	QTY -053	P/N	DESCRIPTION
X							D130-1048-011	BASIC SKIDTUBE INSTALLATION, LH
	X						D130-1048-012	BASIC SKIDTUBE INSTALLATION, RH
		X					D130-1048-013	HEAVY DUTY SKIDTUBE INSTALLATION, LH
			X				D130-1048-014	HEAVY DUTY SKIDTUBE INSTALLATION, RH
1		1		X			D130-1048-051 (2)(3)	REPLACEMENT WEARPLATES, LH
	1		1		X		D130-1048-052 (2)(3)	REPLACEMENT WEARPLATES, RH
		1	1			X	D130-1048-053 (3)	MIDTUBE WEARPLATE KIT
1		1					D130-1048-041	SKIDTUBE ASSY, LH
	1		1				D130-1048-042	SKIDTUBE ASSY, RH
				1			D5465-1	FWD WEARPLATE, LH
					1		D5465-2	FWD WEARPLATE, RH
				1	1		D5478-1	AFT WEARPLATE
						1	D5613-041	MIDTUBE WEARPLATE
				8	8		AN3C5A	BOLT
				8	8		NAS1149C0332R	WASHER
						2	D5678-1 (4)	NUT
						2	D4012-1	CUSHION
		1	1				D5569-1 (3)	HEAVY DUTY SKIDTUBE BLADE
1	1						D5569-3 (2)	SKIDTUBE BLADE
1	1	1	1				D5570-1 (2)(3)	BLADE PLUG
1	1	1	1				22201BC120090L (1)(2)(3)	BOLT
1	1	1	1				23111AG120LE (1)(2)(3)	WASHER (or NAS1149C0832R)
1	1	1	1				ASN52320BH120N (1)(2)(3)	NUT
6	6	6	6				D5594-1 (2)(3)	GH BUSHING
6	6	6	6				D5594-3 (2)(3)	GH WASHER
3	3	3	3				AN8C56A (2)(3)	BOLT
3	3	3	3				NAS1149C0832R (2)(3)	WASHER
3	3	3	3				NAS1291C8 (2)(3)	NUT
1	1	1	1				DHS411-101.3106 (1)	BOLT
1	1	1	1				23111AG100LE (1)	WASHER (or NAS1149C0732R)
1	1	1	1				ASNA0045BC100L (1)	NUT, CASTELLATED
1	1	1	1				EN2367-18026 (1)	COTTER PIN (or MS24665-231)
20	20	20	20				MS21141S0605	MAXIBOLT, BLIND, PAN HEAD (or CR7621S06-05)

- (1) Airbus Helicopter Part Numbers (or alternative) included in kit
 (2) Pre-assembled on D130-1048-011/-012 Skidtube
 (3) Pre-assembled on D130-1048-013/-014 Skidtube
 (4) Pre-assembled on D5613-041 Midtube Wearplate

Change Record

Part Number: D130-1048-012

PAGE 1 OF 1

Description: SKIDTUBE INSTALLATION, RH[illegible]